

Date: Tuesday, 1/16/2007 11:28:52 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 30276A		
Estimate Number	: 10452		
P.O. Number	: N/A	Part Number	: D32781
This Issue	: 1/16/2007 S.O. No. : N/A	Drawing Number	: D3278 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 30150A	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 1/26/2007
Checked & Approved By	: <i>[Signature]</i> 01.01.16	Qty:	40 Um: Each
Comment	: Est:A 04.04.18 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.2454 f(s)/Unit Total: 9.8154 f(s) *M19295*  
Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick  
(M6061T6B1.000x02.000) Batch: *En 07/01/24 (X45)*

2.0	SHEAR	<del>SHEAR</del> <i>BAND SAW</i>
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Comment: ~~SHEAR~~ *BAND SAW*  
Cut blank: 2.00" x 1.00" x 2.550" long

*En 07/01/24 (X45)*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
1- Machine as per Folio FA405 and Dwg D3278  
2- Deburr and Tumble  
Identify as D3278-1

*PAO*

*JL En 07/01/25 40*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JL En 07/01/25 40*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J-F 07/01/27 (40)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-1 PAR #: N/A Fault Category: Prod / Machined Parts NCR: (Yes) No DQA: 9 Date: 07/02/06  
 QA: N/C Closed: 18 Date: 07.02.06

NCR: <u>30276A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/07	17 S.O	5 (five) parts scrap Parts didn't sit flat when machined dim 0.119" ± 0.005 Positioning was wrong	<u>2</u> 07/01/07	Scrap and destroy - <del>out</del> <del>extra</del> →	<u>3</u> 07/01/07	<u>2</u> 07/01/07	<u>2</u> 07/01/07	<u>2</u> 07/01/07

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:28:53 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 30276A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YJ / a.m

07-01-31 46

7.0

POWDER COATING

POWDER COATING



M103141



(40X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-A / Y

07/02/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

R 7/02/05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

CPB 07/02/05

R

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/06

Job Completion



U 07/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30276A
<b>Description:</b> Support		<b>Part Number:</b>	D3278-1
<b>Inspection Dwg:</b> D3278	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.097	—		vern	
0.359	+/-0.005	0.356	—		"	
0.609 <del>0.615</del>	+/-0.010	0.608	—		"	
0.250	+/-0.010	0.251	—		"	
1.480	+/-0.005	1.479			"	
R0.125	+/-0.010	0.125	—		R-g	
0.119	+0.005/-0.004	0.115	—		0.1" mic	
2.439	+/-0.010	2.440	—		vern	
1.980	+/-0.010	1.983	—		vern	
R0.130	+/-0.010	0.130	—		R-g	
Ø0.257	+0.005/-0.000	0.260	—		vern	
R0.375	+/-0.010	0.375	—		R-g	
0.875	+/-0.010	0.872	—		vern	
0.500	+/-0.010	0.504	—		vern	
R0.400	+/-0.010	0.400	—		R-g	
1.720	+/-0.010	1.722	—		vern	
R0.125	+/-0.010	0.125	—		R-g	
0.125	+/-0.010	0.126	—		vern	

<b>Measured by:</b> E	<b>Audited by:</b> JR	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/01/24	<b>Date:</b> 07.01.24	<b>Date:</b>	N/A

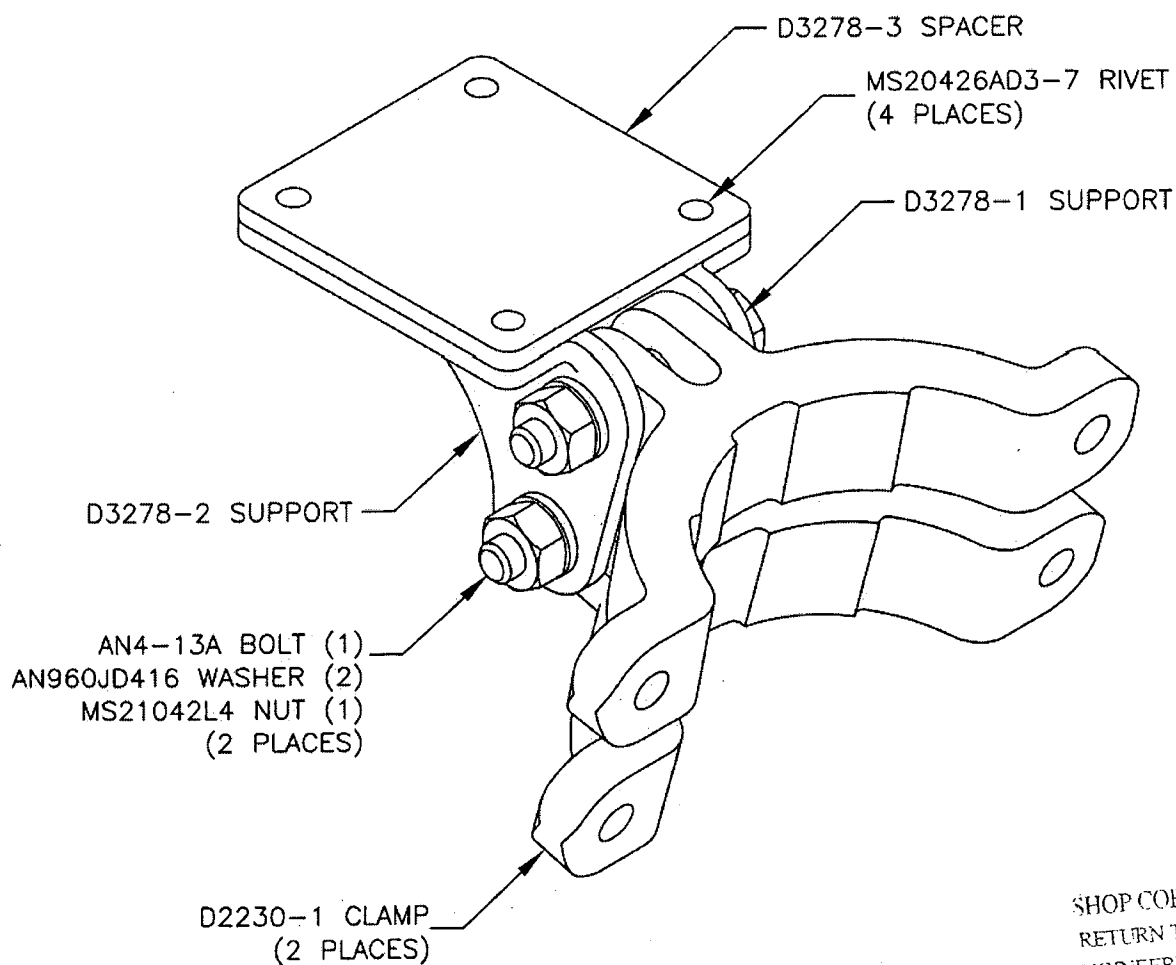
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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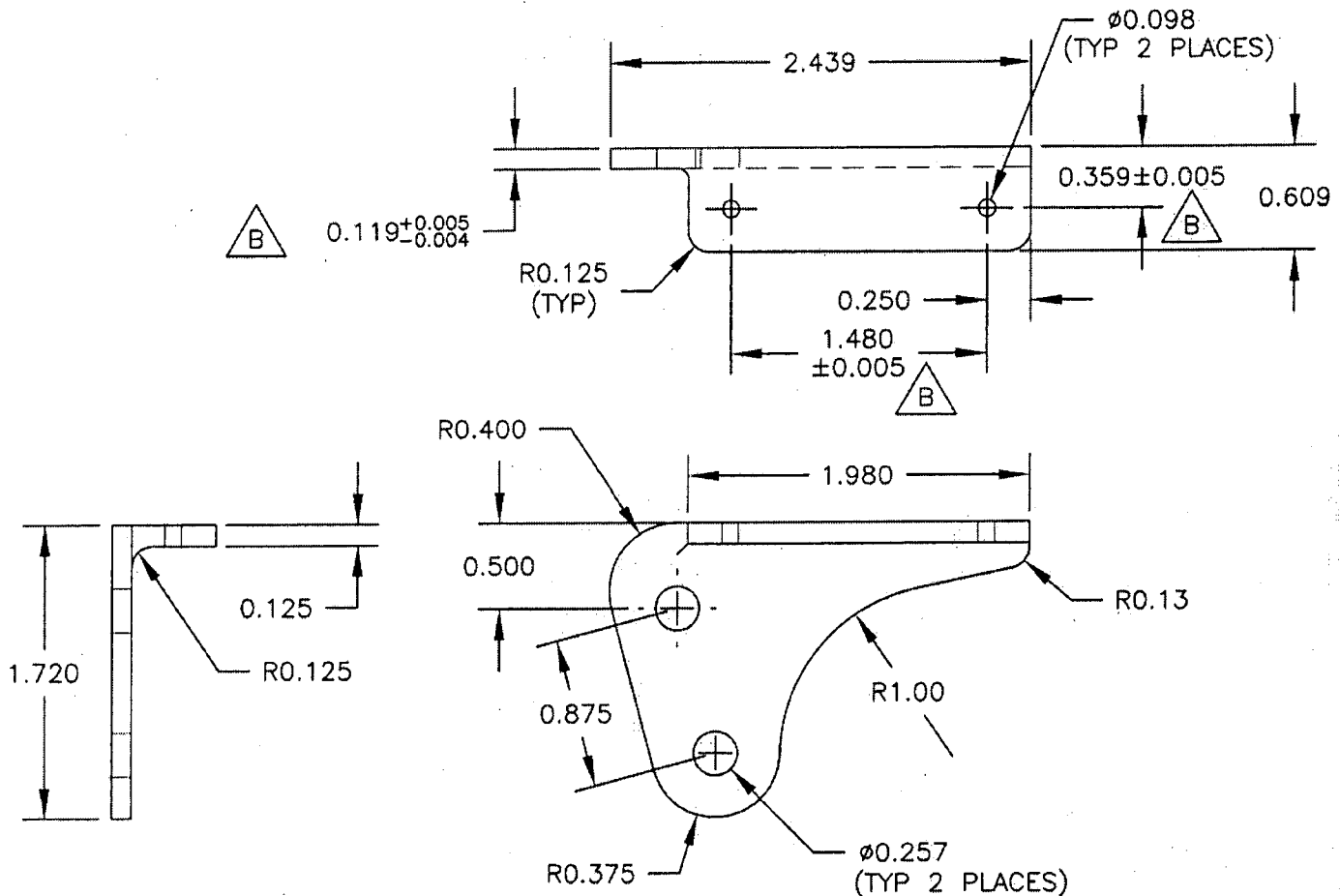
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

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05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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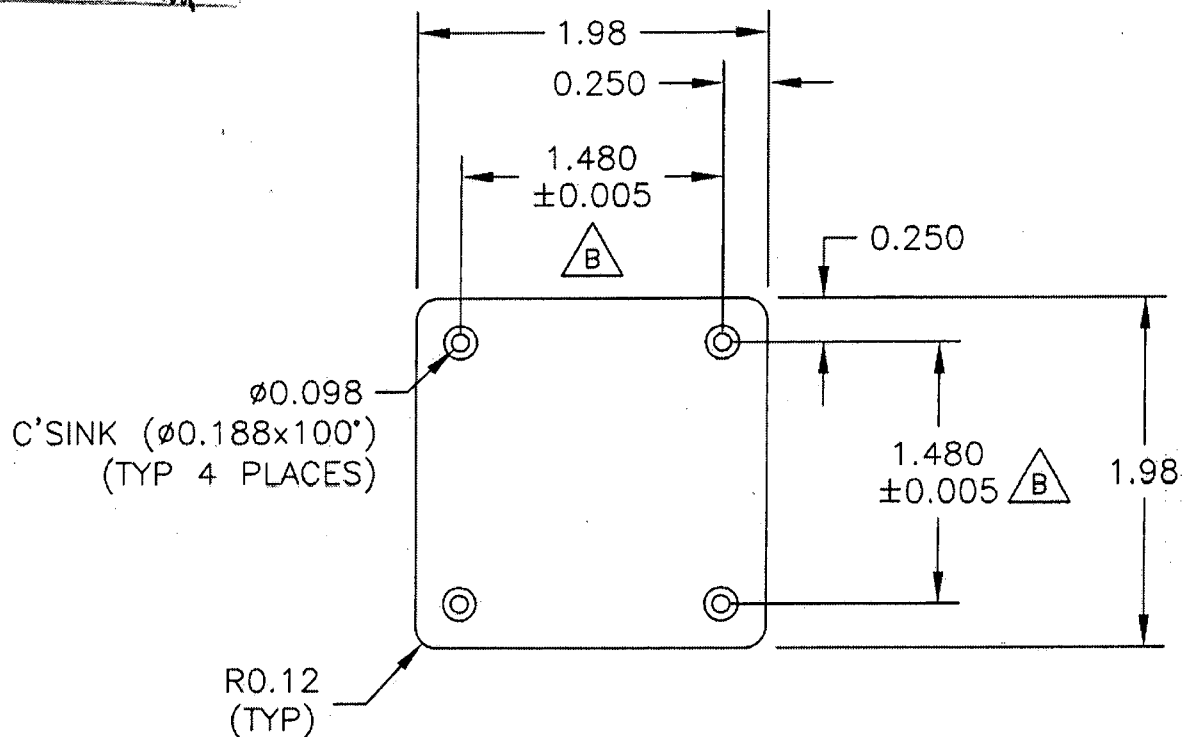
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

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**D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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